

SLUT
Work Order ID 68724-2

Wednesday, April 20, 2011 10:22:41 AM

Page 1

Item ID: D4292-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

(2)

Start Date: 4/20/2011 Start Qty: 4.00

Required Date: 4/25/2011 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID.	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4292

C

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 6.250"

Batch: 9116 930

GRAIN DIRECTION MUST BE ALONG 4.00"**

11/06/21

2

φ

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB002

DWG REV: C

FOLIO REV: AA

B.A 11/06/22

2

φ

2- deburr rough edges

Work Order ID 68724

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Page 2

Item ID: D4292-1

Accept

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Required Date: 4/25/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B-a 11/06/22

2

0

121

0.00

Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL & TAP FOR HELICOIL AS PER DWG

11/06/23

2

122

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

11/06/23

2

Work Order ID 68724

Wednesday, April 20, 2011 10:22:41 AM

Page 3

Item ID: D4292-1

Revision ID:

Item Name: Fitting

Start Date: 4/20/2011 Start Qty: 4.00

Required Date: 4/25/2011 Req'd Qty: 4.00

Reference:

Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

MASK THREADED HOLE

2 BK 11-6-24

2 & BK 11-6-30

Work Order ID 68724

Wednesday, April 20, 2011 10:22:41 AM

Page 4

Item ID: D4292-1

Accept

Revision ID:

Item Name: Fitting

Start Date: 4/20/2011 Start Qty: 4.00

Required Date: 4/25/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 0 11/09/36

151

0.00



Small Fab

Memo

0.00

Small Fab

INSTAL HELICOIL

4511/07/04 (2)

152

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sumatra

(70)

Work Order ID 68724

Wednesday, April 20, 2011 10:22:41 AM

Page 5

Item ID: D4292-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Fitting

Start Date: 4/20/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: Y70

0.00



Packaging

Memo

0.00

Packaging

11/7/14 SP (2)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/14 SP
CL 11/10/109

Picklist Print

Wednesday, April 20, 2011 10:22:47 AM

Page 1

Work Order ID: 68724

Parent Item: D4292-1

Parent Item Name: Fitting



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M7075T73B4.000x4.00 0		Purchased	No			100	f	19.1210	0.52	2.189474			
--------------------------	--	-----------	----	--	--	-----	---	---------	------	----------	--	--	--



7075-T73 Bar 4.0 x 4.0



Location	Loc Qty	Loc Code
MAT005	19.121	
116153	0.75	
116324	7.95	
116764	6	
116867	0.041	
116930	4.38	

MS21209F1-10	Purchased	No				Each	92.0000						
--------------	-----------	----	--	--	--	------	---------	--	--	--	--	--	--



HELI COIL



Location	Loc Qty	Loc Code
ST305	92	
116977	92	

12.18
4
11/7/11 SP
OK 11/06/11

2

DART AEROSPACE LTD		Work Order: 68724
Description: FITTING		Part Number: D4292-1
Inspection Dwg: D4292 Rev: C		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.272	W0.272 ^{+0.006} / _{-0.001}	Ø 0.273	✓		Vern	GA-01
Ø 0.266	W0.266 ^{+0.006} / _{-0.001}	Ø 0.268	✓		"	"
1.75	+/- .030	1.754	✓		"	"
R0.25	+/- .030	R0.250	✓		R-6	ref.
R0.06	+/- .030	R0.063	✓		"	"
4.875	+/- .010	4.875	✓		Vern	GA-01
0.493	+/- .010	0.495	✓		"	"
CORE Ø 0.765	+/- .010	Ø 0.766	✓		"	"
0.250	±.030 / - .010	0.252	✓		Mic	GA-03
0.680	+/- .010	0.680	✓		Vern	GA-01
2.250	+/- .010	2.251	✓		H-6	31006
4.500	+/- .010	4.501	✓		Vern	GA-01
R1.275	+/- .010	R1.275	✓		R-6	ref.
R0.031	+/- .010	R0.032	✓		"	"
R0.13	+/- .030	R0.125	✓		"	"
1.65	+/- .030	1.655	✓		Vern	GA-01
1.421	+/- .010	1.421	✓		"	"
1.063	± .010	1.055	—		RA26	Jern
.663	± .010	.667	—		RA26	"
Ø .381	±.000 / - .001	.381	—		"	"
.320X100°	—	.320X100°	—		"	"

Measured by: B.A./amf	Audited by: PR	Preliminary Approval:
Date: 11/06/22	Date: 11-6-23	Date: 11/06/23

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD	Work Order: 68724
Description: FITTING	Part Number: D4292-1
Inspection Dwg: D4292 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/- .010	R0.063	✓		R-6	ref.
0.250	+0.030/-0.010	0.259	✓		Vern	GA-01
0.125	+0.030/-0.010	0.131	✓		"	"
2.95	+/-0.030	2.955	✓		"	"
0.275	+/-0.010	0.275	✓		"	"
0.800	+/-0.010	0.800	✓		"	"
0.825	+/-0.010	0.825	✓		"	"
0.375	+/-0.010	0.374	✓		"	"
0.31	+/-0.030	0.312	✓		"	"
0.88	+/-0.030	0.884	✓		"	"
0.663	+/-0.010	0.661	✓		"	ML-7
Ø0.381	+0.000/-0.001	Ø0.381	✓		"	"
1.125	+/-0.010	1.125	✓		"	"
1.063	+/-0.010	1.063	✓		"	"
3.44	+/-0.030	3.438	✓		Vern	GA-01
2.450	+/-0.010	2.450	✓		"	"
1.325	+/-0.010	1.326	✓		"	"
0.300	+/-0.010	0.301	✓		"	"
1.200	+/-0.010	1.200	✓		"	"
2.84	+/-0.030	2.835	✓		"	"
0.19	+/-0.030	0.191	✓		"	"
5.86	+/-0.030	5.864	✓		"	"
5.99	+/-0.030	5.992	✓		"	"

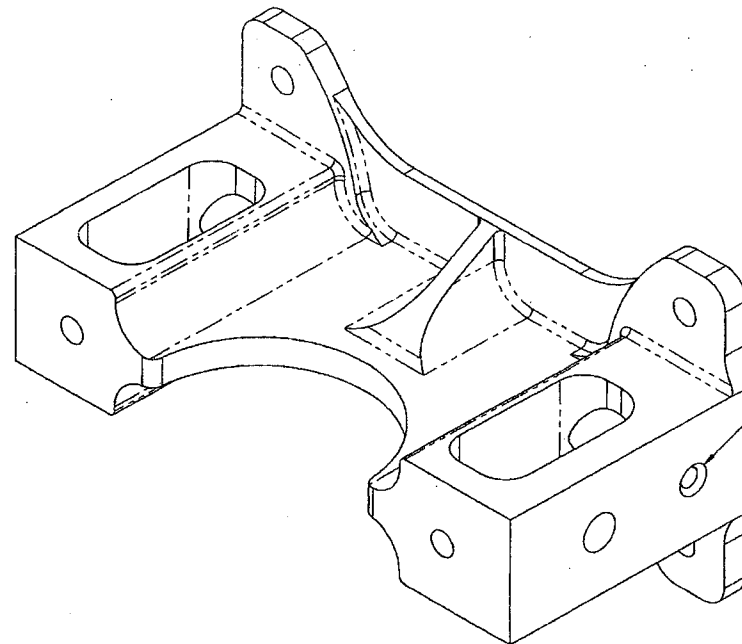
Measured by: B.A. / <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 11/06/22	Date: 11.6.23	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	<i>[Signature]</i>

[Signature] 10.04.15

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *C.E. 724*

11-09-20



MS21209F1-10 HELICAL COIL, 1X
REF



D4292-1 FITTING

RELEASED
2011-02-01

NOTES:

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4292-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.02 lbs

C	1.064 WAS 1.235 (C1-2), ϕ 0.266 WAS ϕ 0.323 (B3-2), ADD HELICAL COIL (D1-2)	CP	10.12.23
B	0.800 WAS 0.78 (C6-2), 0.825 WAS 0.81 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4292	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FITTING (206L/407 FWD)	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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6

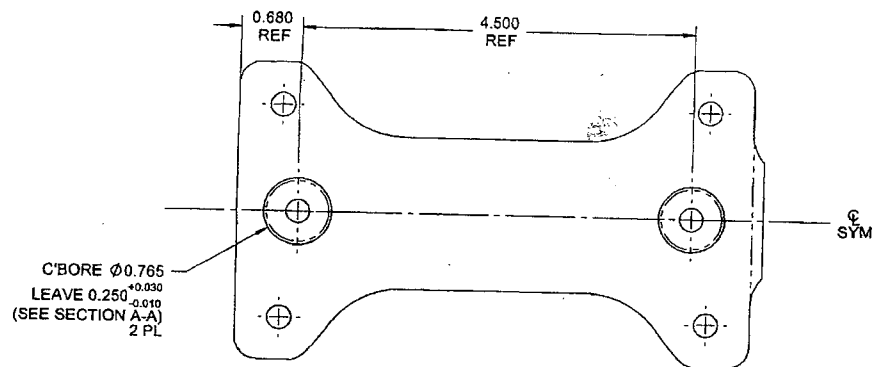
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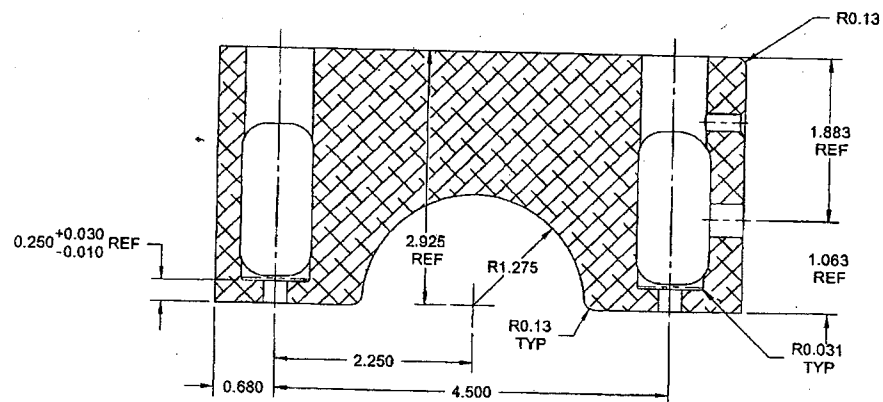
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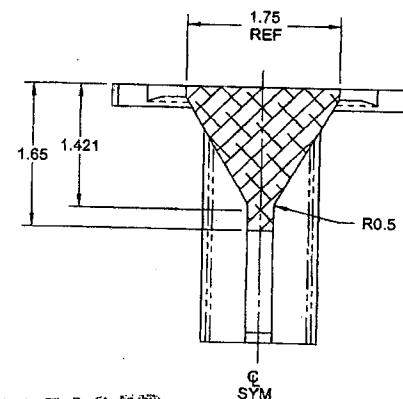
1



VIEW C-C D3-2



SECTION A-A A3-2



SECTION B-B C4-2

RELEASED
2011-02-01

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4292
MFG. APPR.		TITLE
APPROVED		SCALE
DE APPR.		NTS
DATE	10.12.23	

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w/1068724